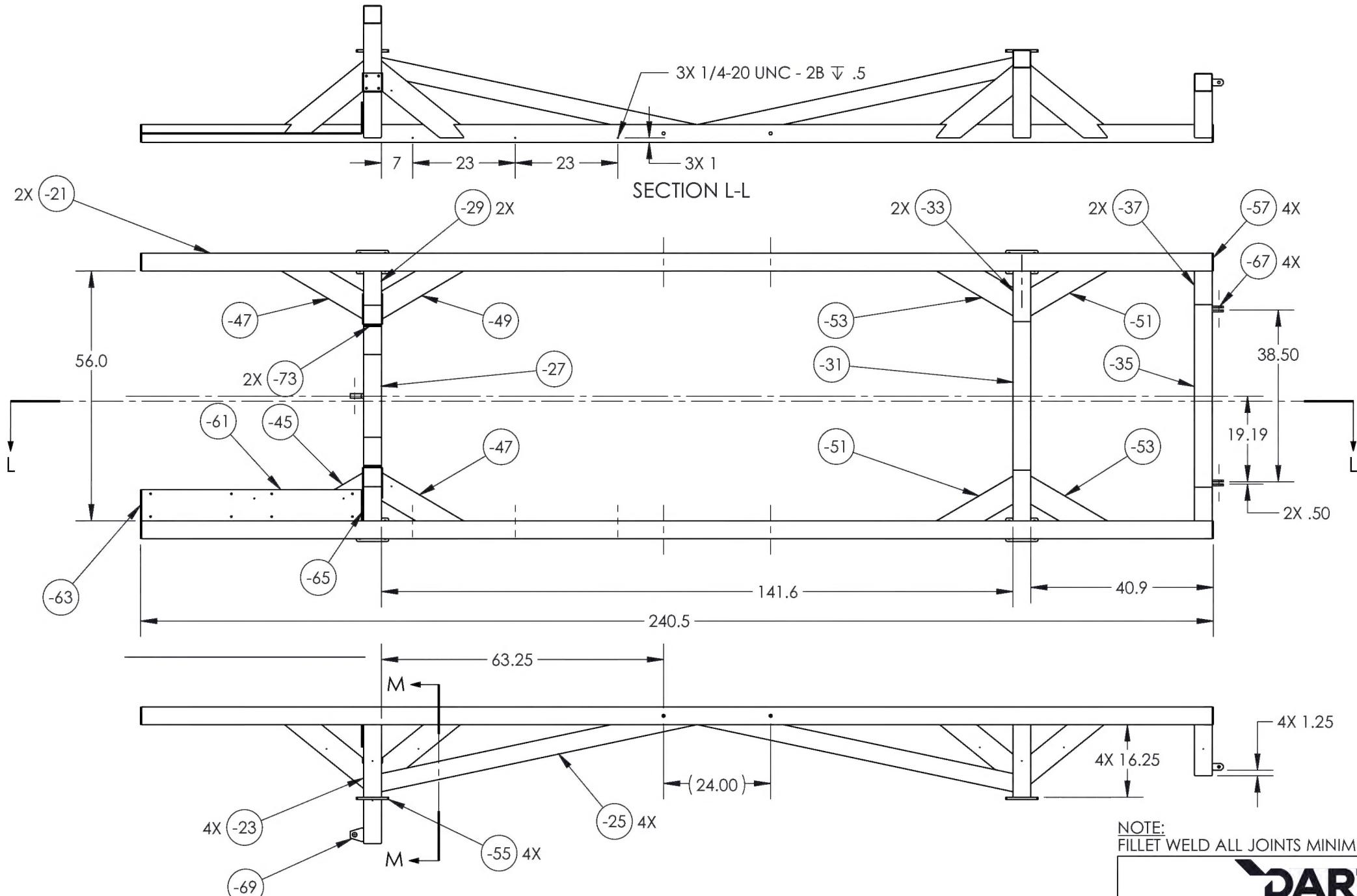
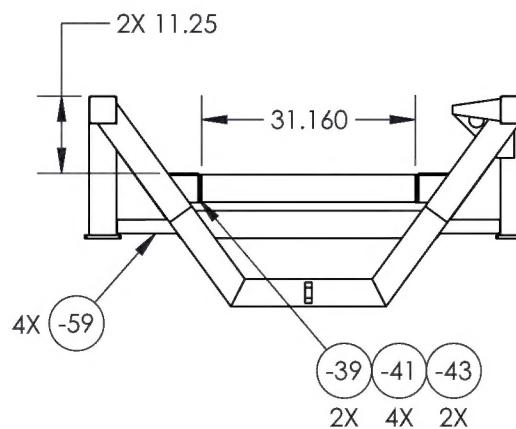
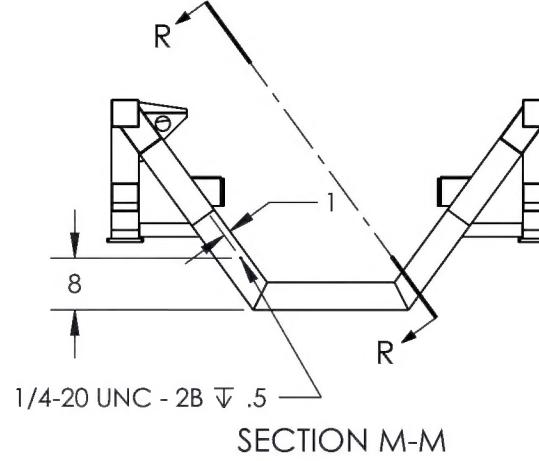
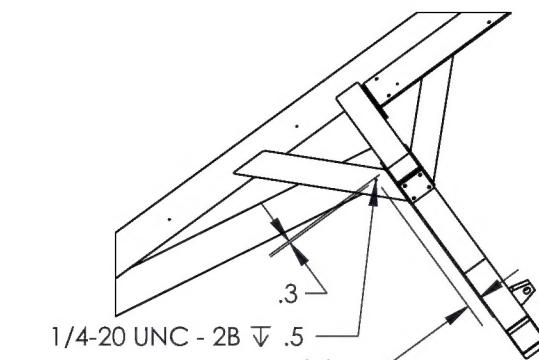


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REV		ECR	DESCRIPTION		DATE	INITIAL	APPROVED
1			RELEASED FOR PRODUCTION.		4/27/2017	SM	JAG



(1)
MAIN FRAME

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-1	
REV 1	
MATERIAL	
HEAT TREAT	
FINISH POWDER COAT YELLOW	
SPEC FED #13538	
DRAWN BY: GILBERT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE 1:28	DATE 3/13/2014
SHEET 1 OF 29	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

.XXX ± .010 FRACTIONS ± 1/8

.XX ± .03 ANGLES ± 1°

X ± .1 SURFACES = 125

✓ 1. BREAK ALL SHARP EDGES

.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY

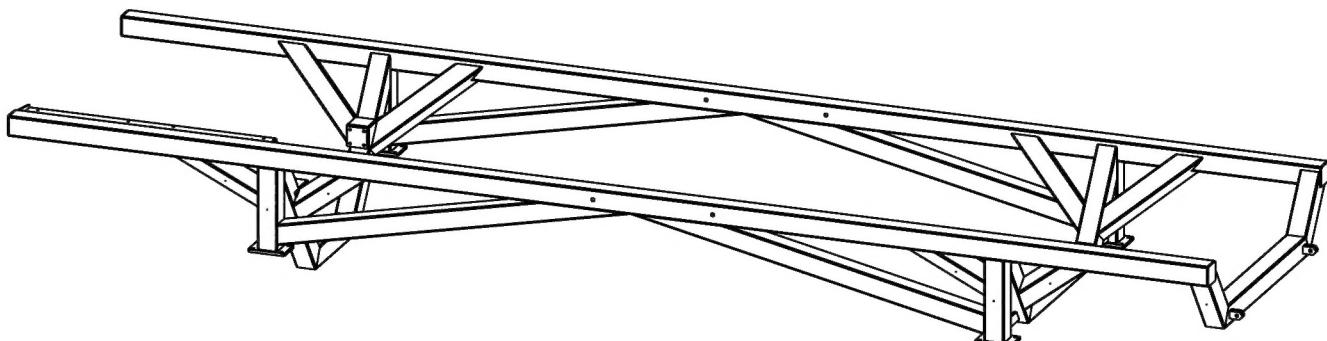
AFTER PLATING

3. INTERPRET DIM AND TOL PER

ASME Y14.5M-2009

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-21	2	TOP RAIL	STEEL TUBE		3
			-23	4	MAIN FRAME UPRIGHT	STEEL TUBE		4
			-25	4	MAIN FRAME OUTSIDE BRACE	STEEL TUBE		5
			-27	1	MAIN FRAME 1 BOTTOM	STEEL TUBE		6
			-29	2	MAIN FRAME 1 SIDE	STEEL TUBE		7
			-31	1	MAIN FRAME 2 BOTTOM	STEEL TUBE		8
			-33	2	MAIN FRAME 2 SIDE	STEEL TUBE		9
			-35	1	MAIN FRAME 3 BOTTOM	STEEL TUBE		10
			-37	2	MAIN FRAME 3 SIDE	STEEL TUBE		11
			-39	2	MAIN FRAME 1 PIVOT	STEEL TUBE		12
			-41	4	MAIN FRAME 1 PIVOT SIDE REINFORCEMENT	A36/1018/1020 HR		13
			-43	2	MAIN FRAME 1 PIVOT TOP REINFORCEMENT	A36/1018/1020 HR		14
			-45	1	MAIN FRAME INSIDE BRACE POWER PACK	STEEL TUBE		15
			-47	2	MAIN FRAME INSIDE BRACE MIRROR	A36/1018/1020 HR		16
			-49	1	MAIN FRAME INSIDE BRACE	STEEL TUBE		17
			-51	2	MAIN FRAME TB INSIDE BRACE	STEEL TUBE		18
			-53	2	MAIN FRAME TB INSIDE BRACE MIRROR	STEEL TUBE		19
			-55	4	MAIN FRAME WHEEL PLATE	A36/1018/1020 HR		20
			-57	4	MAIN FRAME END CAP	A36/1018/1020 HR		21
			-59	4	MAIN FRAME 2 UPRIGHT BRACE	A36/1018/1020 HR		22
			-61	1	MAIN FRAME POWER PACK BASE	A36/1018/1020 HR		23
			-63	1	MAIN FRAME POWER PACK GUSSET	A36/1018/1020 HR		24
			-65	1	MAIN FRAME POWER PACK GUSSET 2	A36/1018/1020 HR		25
			-67	4	MAIN FRAME TOWBAR MOUNT	A36/1018/1020 HR		26
			-69	1	MAIN FRAME 1 PISTON TAB	A36/1018/1020 HR		27
X			-73	2	WELDED PIVOT PLATE ASSEMBLY			28
1			-75		MAIN FRAME WELD PIVOT PLATE	A36/1018/1020 HR		29
4	B/O		-77		HEX NUT	STEEL	3/8-24 (MCMASTER-CARR #90499A815)	28
	-73 ASSY							



SUPPORT DOLLY, TAILBOOM

DWG NO.

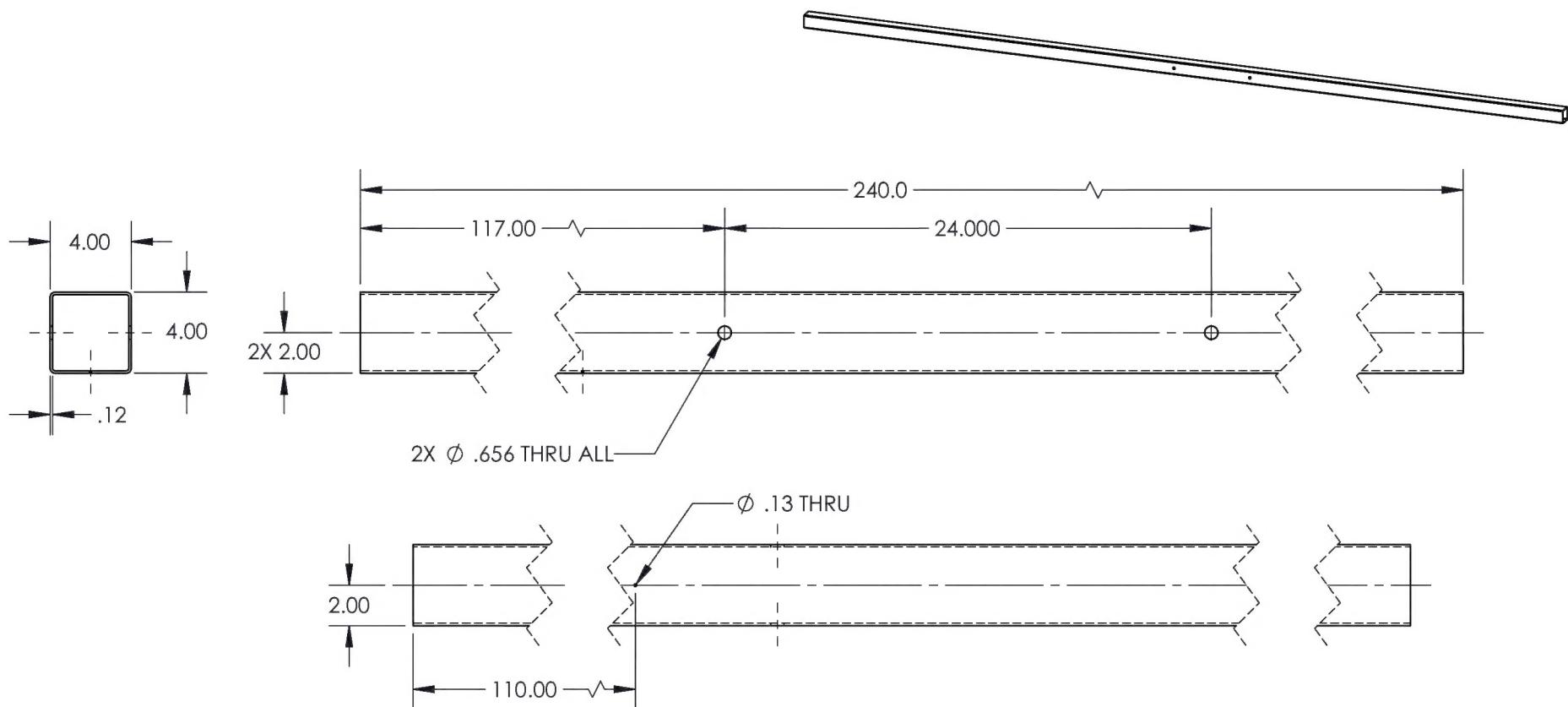
RB T102012-1

REVIEW

MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
HEAT	<u>.XXX ± .010 FRACTIONS ± 1/8</u>		
TREAT	<u>.XX ± .03 ANGLES ± 1°</u>		
FINISH	POWDER COAT YELLOW <u>.X ± .1 SURFACES = 125</u>		
SPEC	FED #13538		
DRAWN BY:	GILBERT		
CHECKED:	CLOUGH		
OPPS APPR:	ANDERSON		
QA APPR:	LINDSAY USED ON MODEL		
APPROVED:	GILBERT BELL 212, 214B, 214ST, 412		
SCALE	1:36	DATE	3/13/2014 SHEET 2 OF 29

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REV		ECR		DESCRIPTION		DATE	INITIAL	APPROVED
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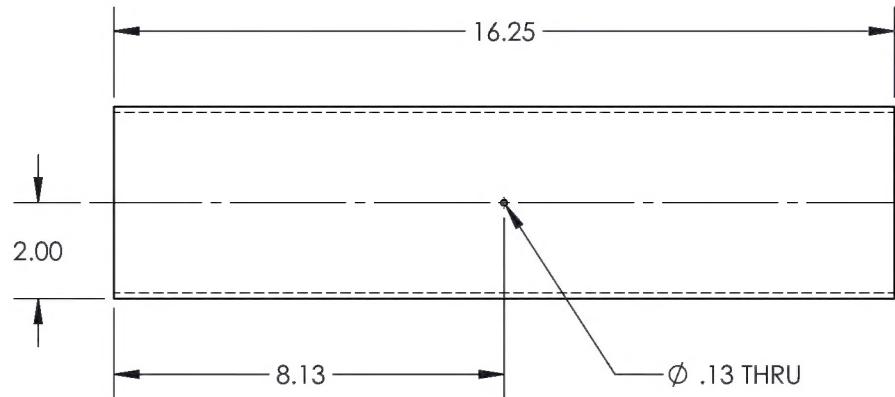
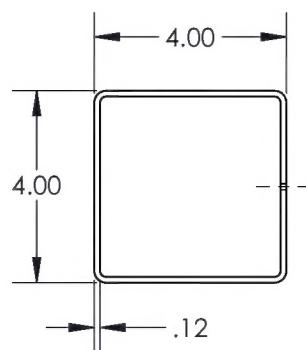
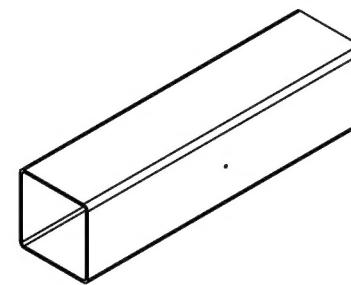
DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-21	
REV	1
MATERIAL STEEL TUBE	
HEAT	
TREAT	
FINISH SEE -1 WELDMENT	
SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
SCALE	1:8
DATE	3/13/2014
SHEET 3 OF 29	

(-21)

TOP RAIL

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REV		ECR		DESCRIPTION			DATE	INITIAL	APPROVED
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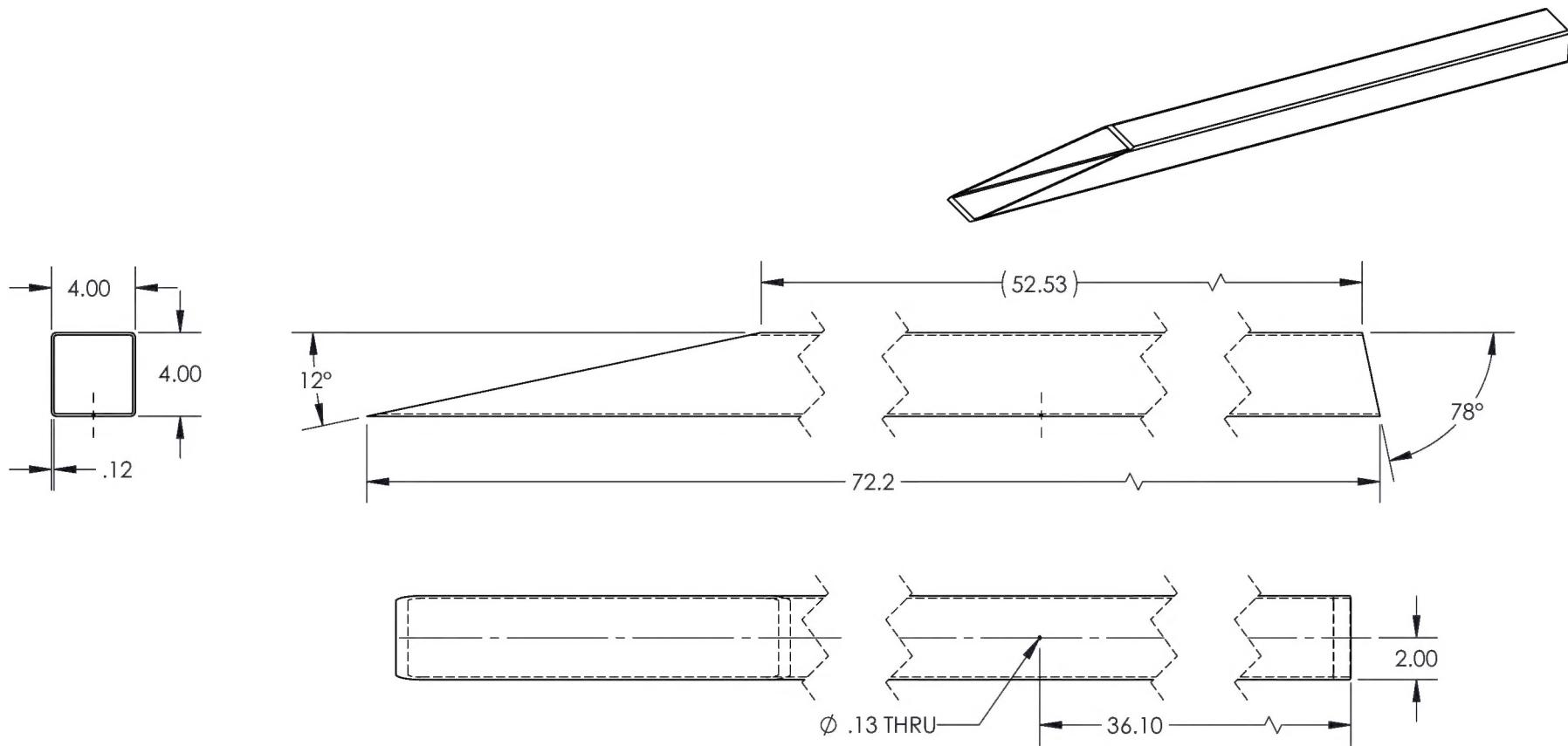
DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-23	
REV 1	
MAT'L STEEL TUBE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT .XXX ± .010 FRACTIONS ± 1/8	
TREAT .XX ± .03 ANGLES ± 1°	
FINISH SEE -1 WELDMENT .X ± .1 SURFACES = 125 ✓	
SPEC	
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE	1:4
DATE	3/13/2014
SHEET 4 OF 29	

(-23)

MAIN FRAME UPRIGHT

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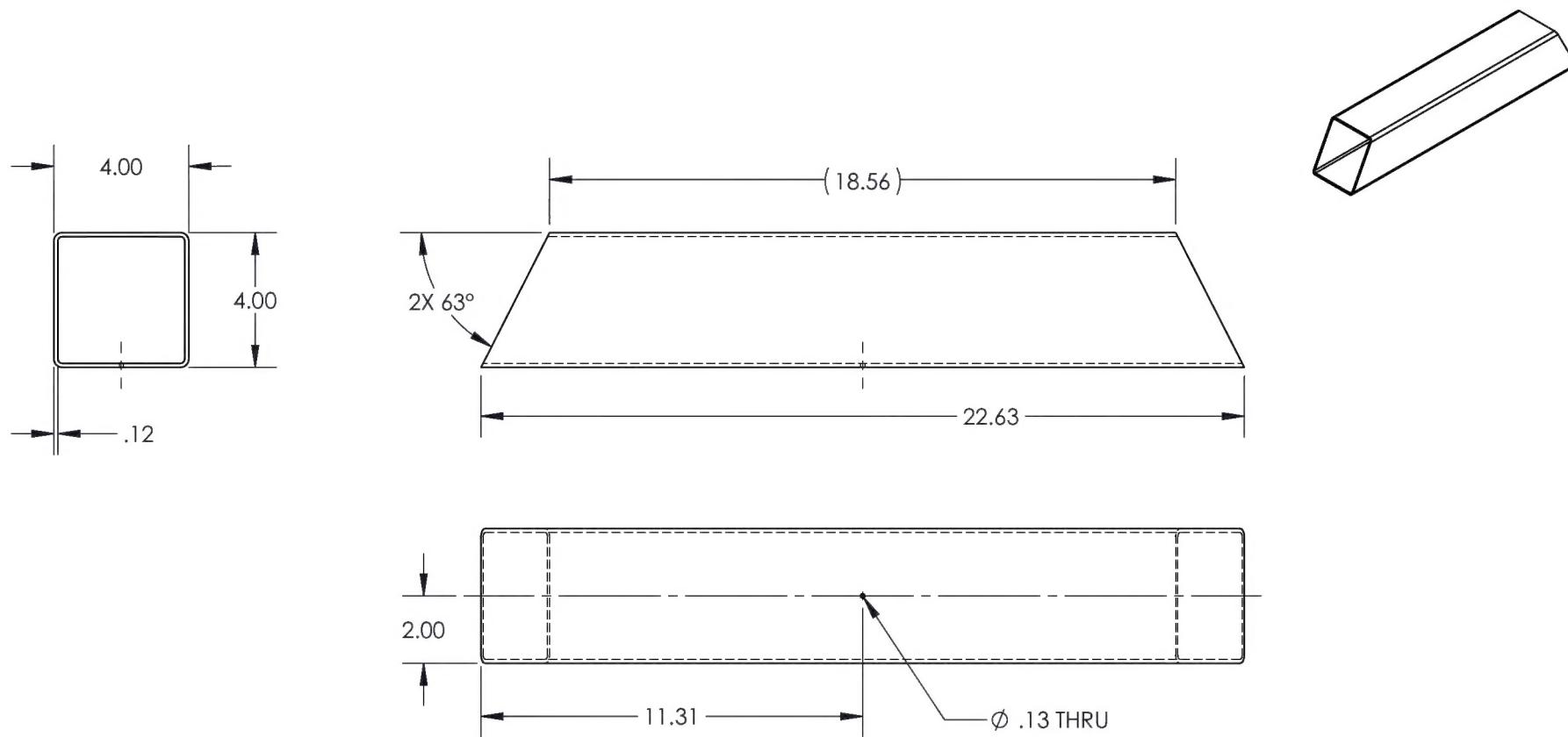
DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	RB T102012-25
REV	1
MATERIAL STEEL TUBE	
HEAT TREAT	
FINISH SEE -1 WELDMENT	
SPEC	
DRAWN BY: GILBERT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE	1:8
DATE	3/13/2014
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SHEET 5 OF 29	

(25)

MAIN FRAME OUTSIDE BRACE

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REV		ECR		DESCRIPTION		DATE	INITIAL	APPROVED
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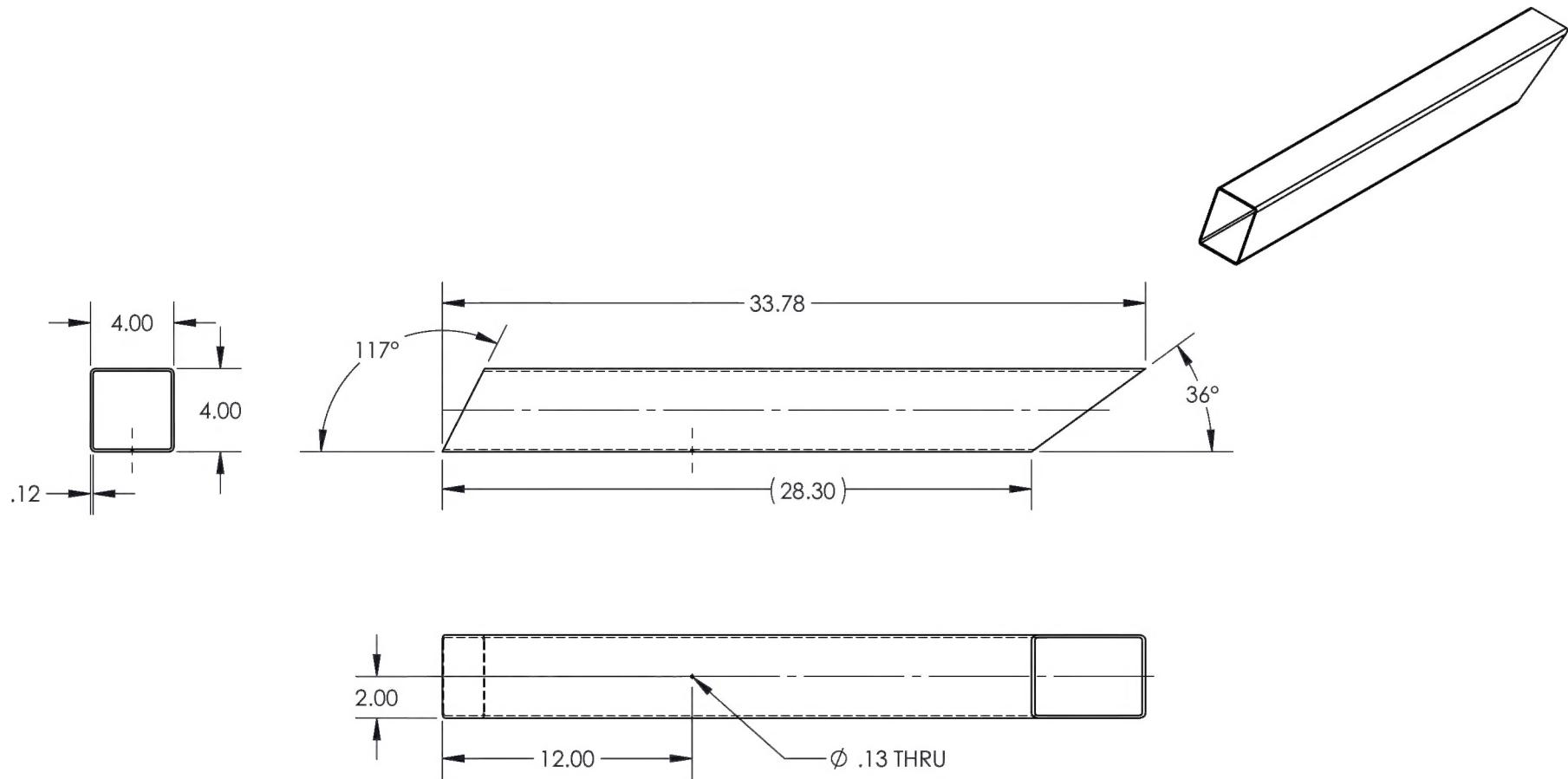
DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-27	
REV	1
MATERIAL STEEL TUBE	
HEAT	
TREAT	
FINISH SEE -1 WELDMENT	
SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
.X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE	1:5
DATE	3/13/2014
SHEET 6 OF 29	

(-27)

MAIN FRAME 1 BOTTOM

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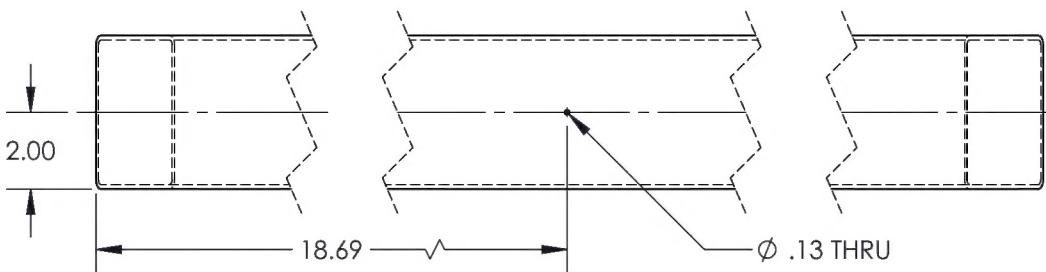
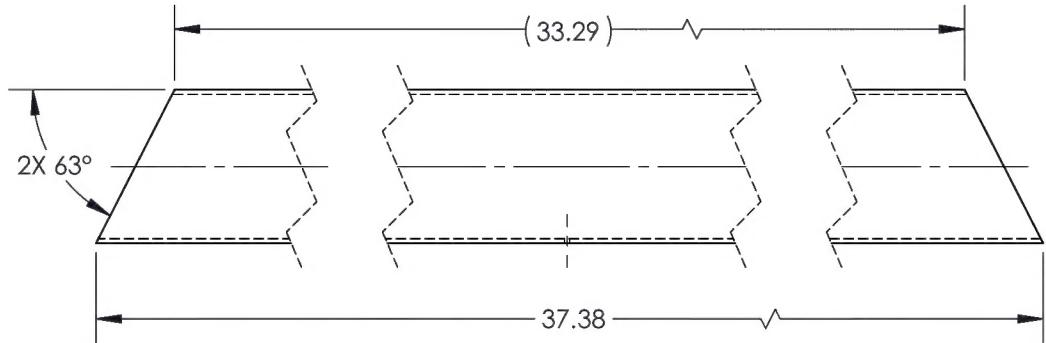
MAIN FRAME 1 SIDE

-29

DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-29	
REV 1	
MATERIAL STEEL TUBE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT XXX ± .010 FRACTIONS ± 1/8	
TREAT XX ± .03 ANGLES ± 1°	
FINISH SEE -1 WELDMENT X ± .1 SURFACES = 125 ✓	
SPEC	
DRAWN BY: GILBERT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL BELL 212, 214B, 214ST, 412	
SCALE	1:8
DATE	3/13/2014
SHEET 7 OF 29	

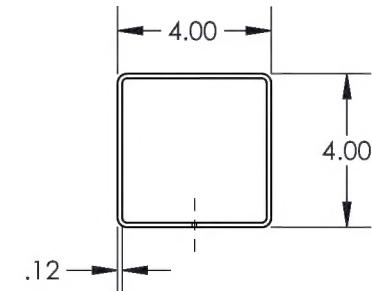
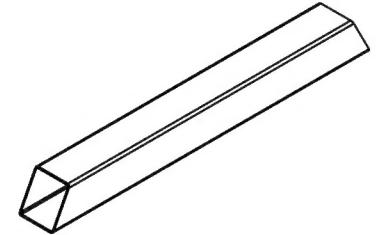
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MAIN FRAME 2 BOTTOM

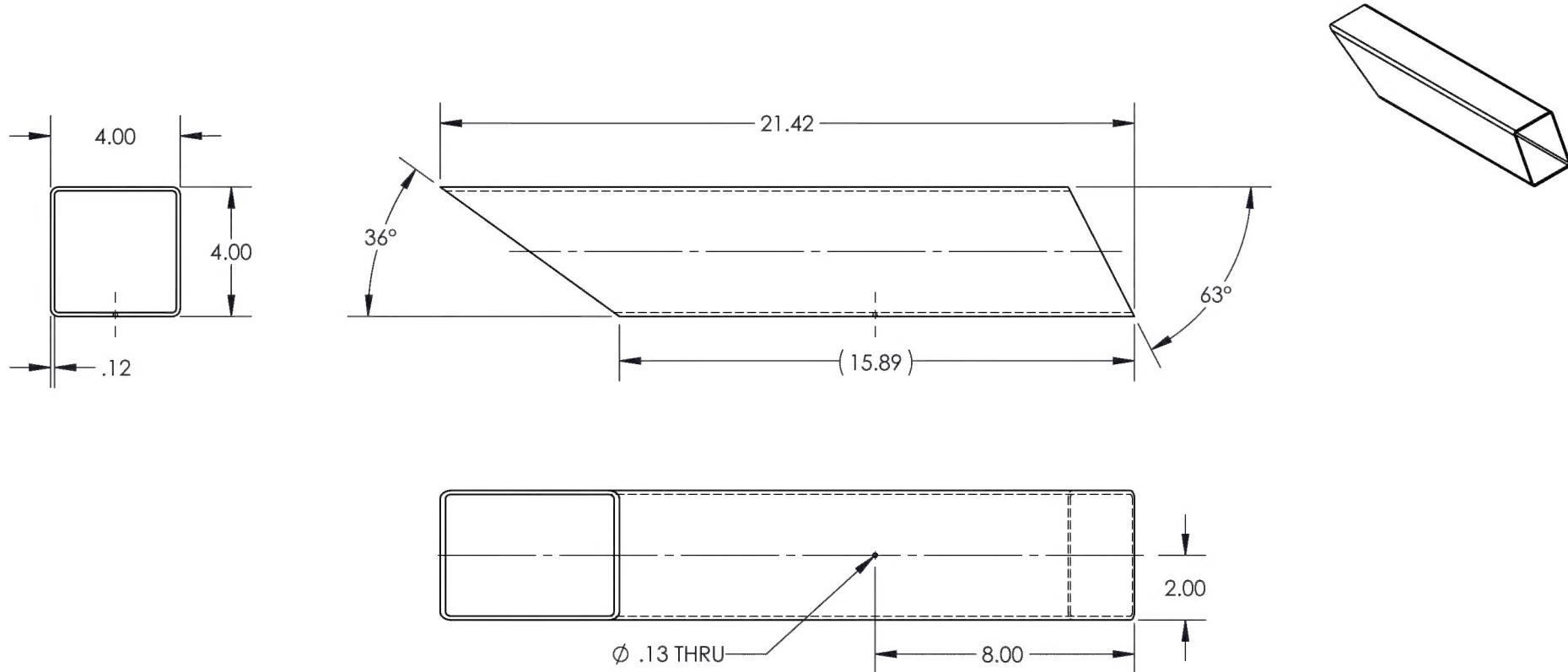
(-31)



DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-31	
REV	1
MATERIAL STEEL TUBE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT .XXX ± .010 FRACTIONS ± 1/8	
TREAT .XX ± .03 ANGLES ± 1°	
FINISH SEE -1 WELDMENT .X ± .1 SURFACES = 125 ✓	
SPEC	
DRAWN BY: GILBERT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL BELL 212, 214B, 214ST, 412	
SCALE	1:5
DATE	3/13/2014
SHEET 8 OF 29	

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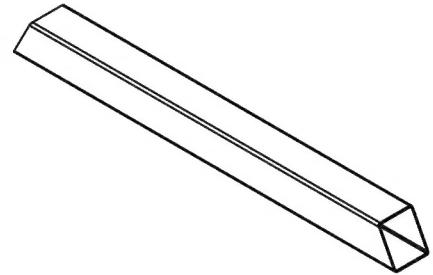
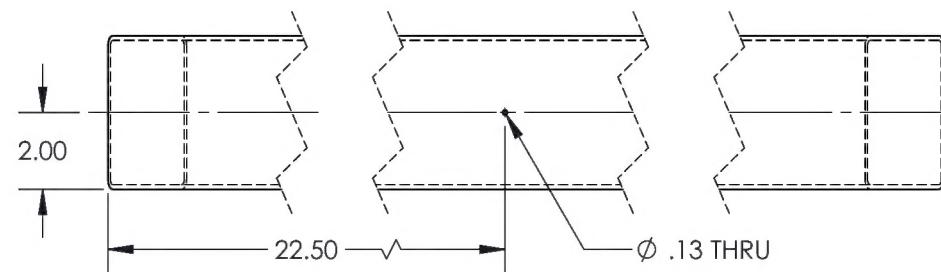
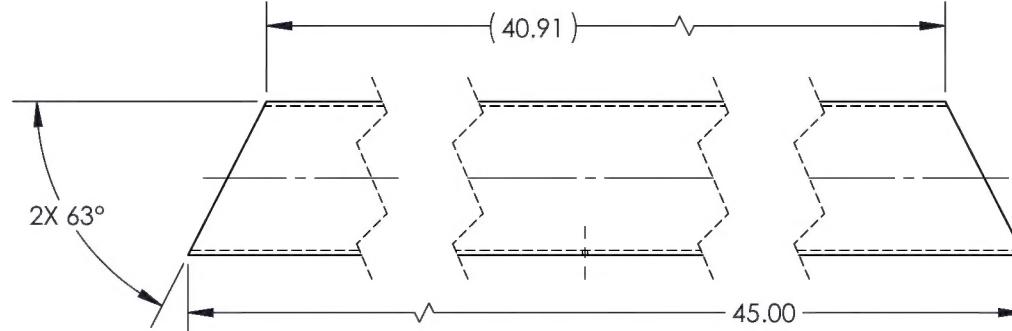
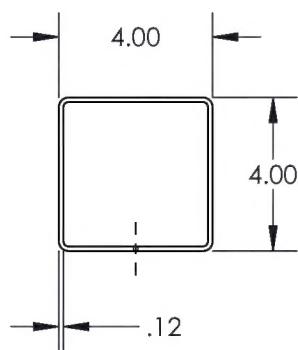
(33)

MAIN FRAME 2 SIDE

DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-33	
REV 1	
MAT'L STEEL TUBE	
HEAT	
TREAT	
FINISH SEE -1 WELDMENT	
SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL	
SCALE	1:5
DATE	3/13/2014
SHEET 9 OF 29	

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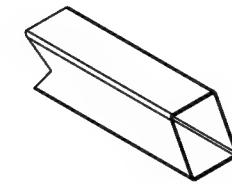
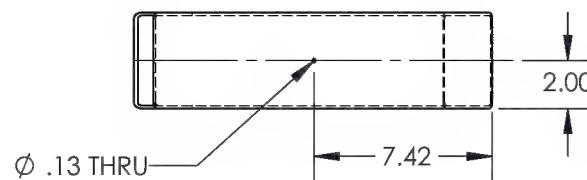
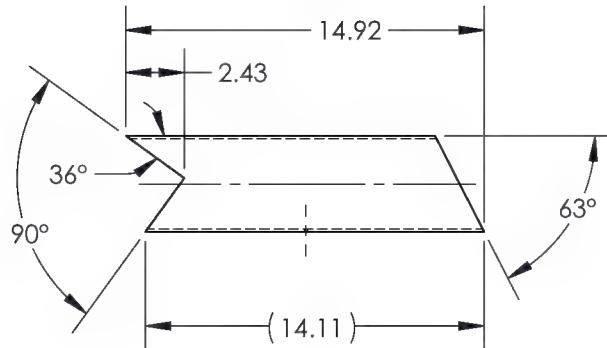
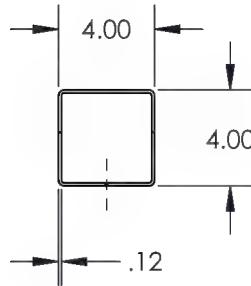
DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-35	
REV	1
MATERIAL STEEL TUBE	
HEAT	
TREAT	
FINISH SEE -1 WELDMENT	
SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
.X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE	1:5
DATE	3/13/2014
SHEET 10 OF 29	

(-35)

MAIN FRAME 3 BOTTOM

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REV		ECR		REVISIONS		
				DESCRIPTION		DATE
				INITIAL	APPROVED	

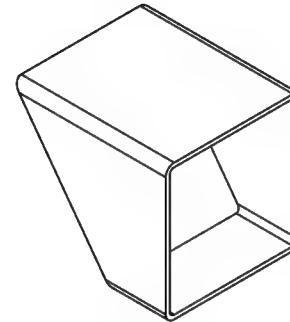
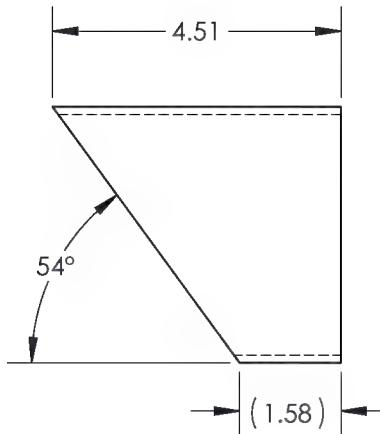
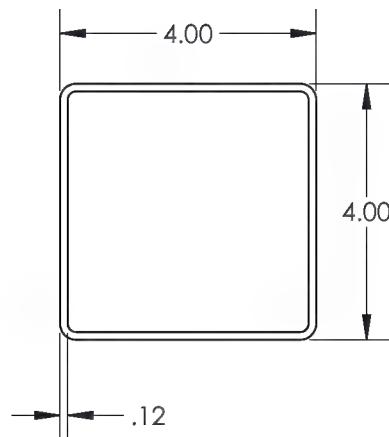


-37
MAIN FRAME 3 SIDE

DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-37	
REV	1
MATERIAL STEEL TUBE	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
TREAT	
FINISH SEE -1 WELDMENT	
SPEC	
ANGLES ± 1°	
.XX ± .03	
X ± .1 SURFACES = 125 ✓	
DRAWN BY: GILBERT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
USED ON MODEL	
APPROVED: GILBERT	
BELL 212, 214B, 214ST, 412	
SCALE	1:8
DATE	3/13/2014
SHEET 11 OF 29	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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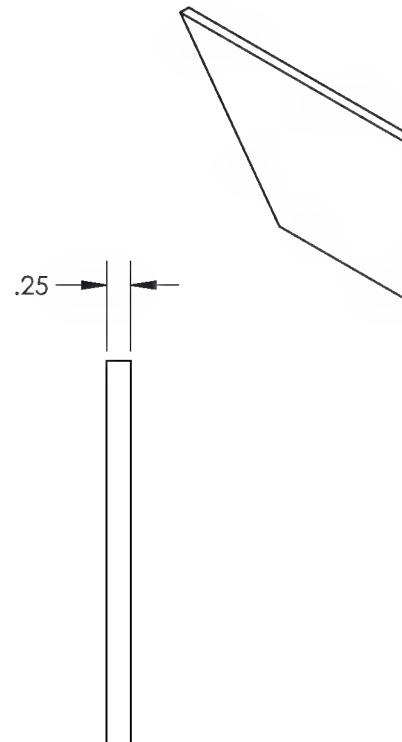
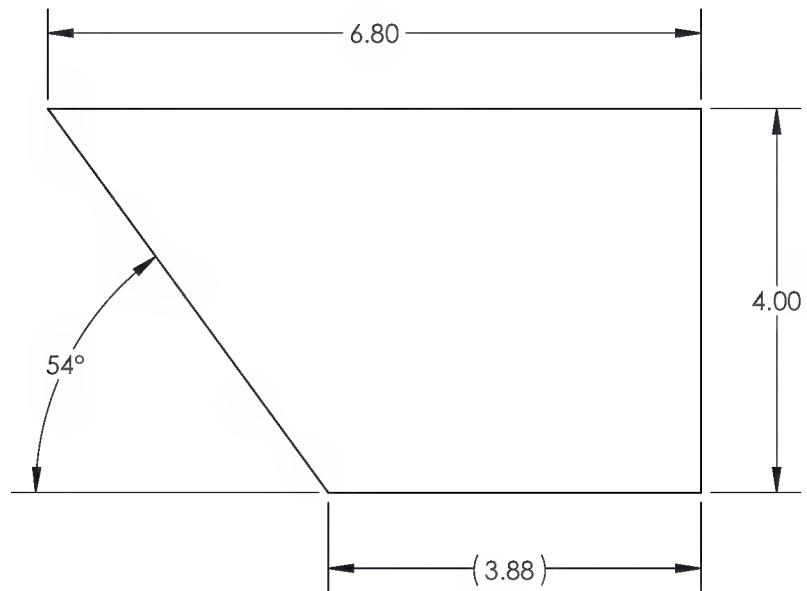
DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-39	
REV	1
MATERIAL STEEL TUBE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
.X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE	1:3
DATE	3/13/2014
SHEET 12 OF 29	

(-39)

MAIN FRAME 1 PIVOT

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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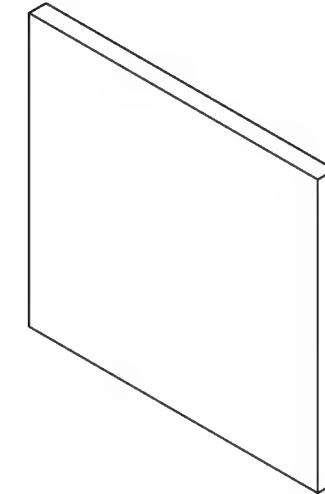
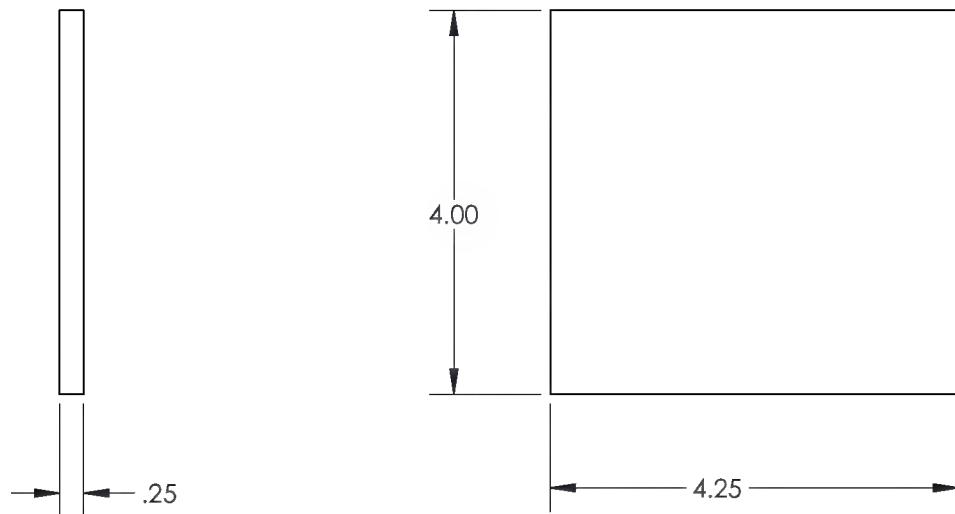
MAIN FRAME 1 PIVOT SIDE REINFORCEMENT

(-41)

DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	RB T102012-41
REV	1
MAT'L A36/1018/1020 HR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH SEE -1 WELDMENT	X ± .1 SURFACES = 125 ✓
SPEC	
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE	1:2
DATE	3/13/2014
SHEET 13 OF 29	

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				DESCRIPTION		DATE
				INITIAL	APPROVED	



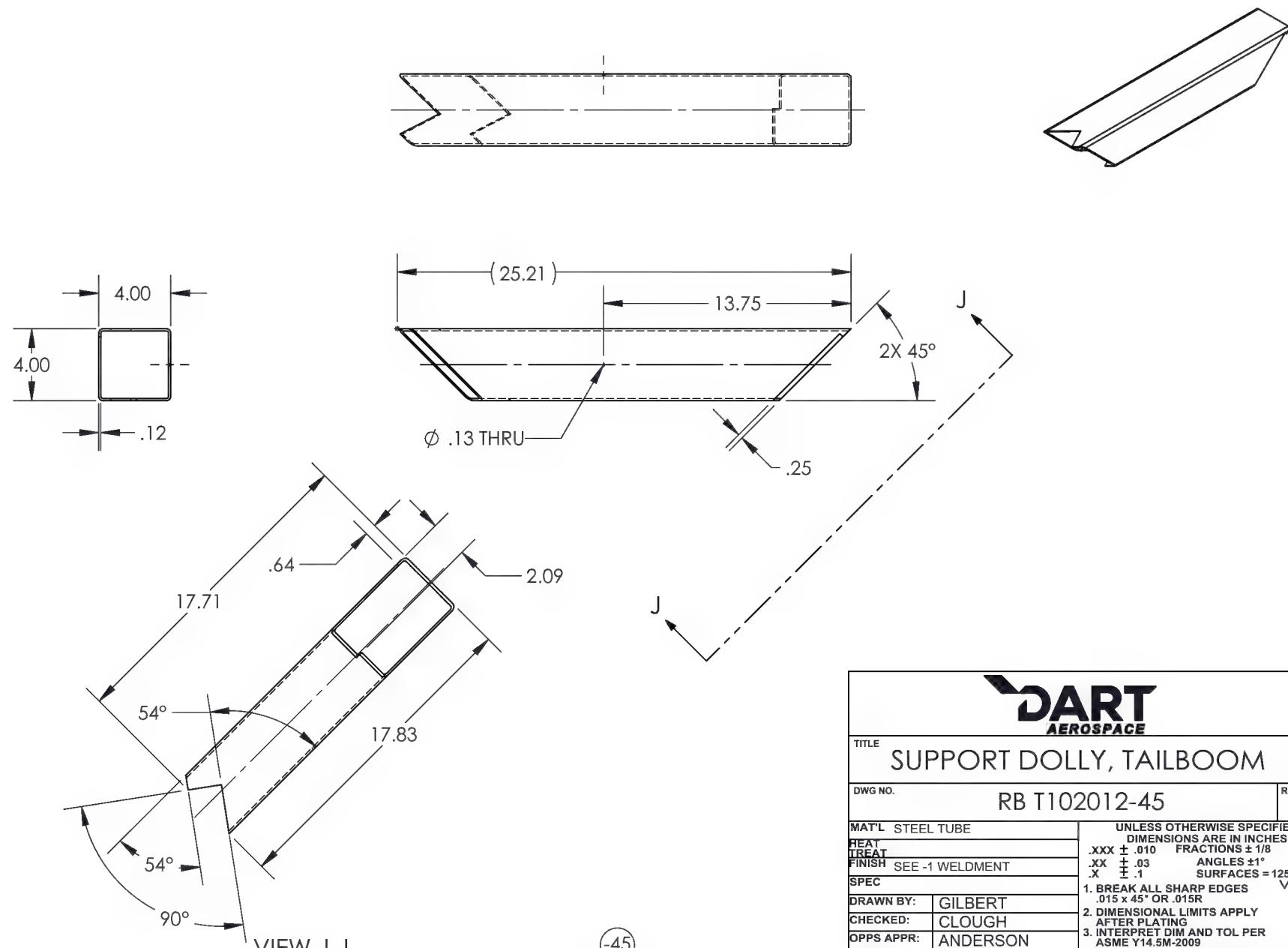
DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-43	
REV 1	
MATERIAL A36/1018/1020 HR UNLESS OTHERWISE SPECIFIED	
HEAT DIMENSIONS ARE IN INCHES	
TREAT .XXX ± .010 FRACTIONS ± 1/8	
FINISH SEE -1 WELDMENT .XX ± .03 ANGLES ± 1°	
SPEC .X ± .1 SURFACES = 125 ✓	
DRAWN BY: GILBERT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY USED ON MODEL	
APPROVED: GILBERT BELL 212, 214B, 214ST, 412	
SCALE	1:2
DATE	3/13/2014
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(-43)

MAIN FRAME 1 PIVOT TOP REINFORCEMENT

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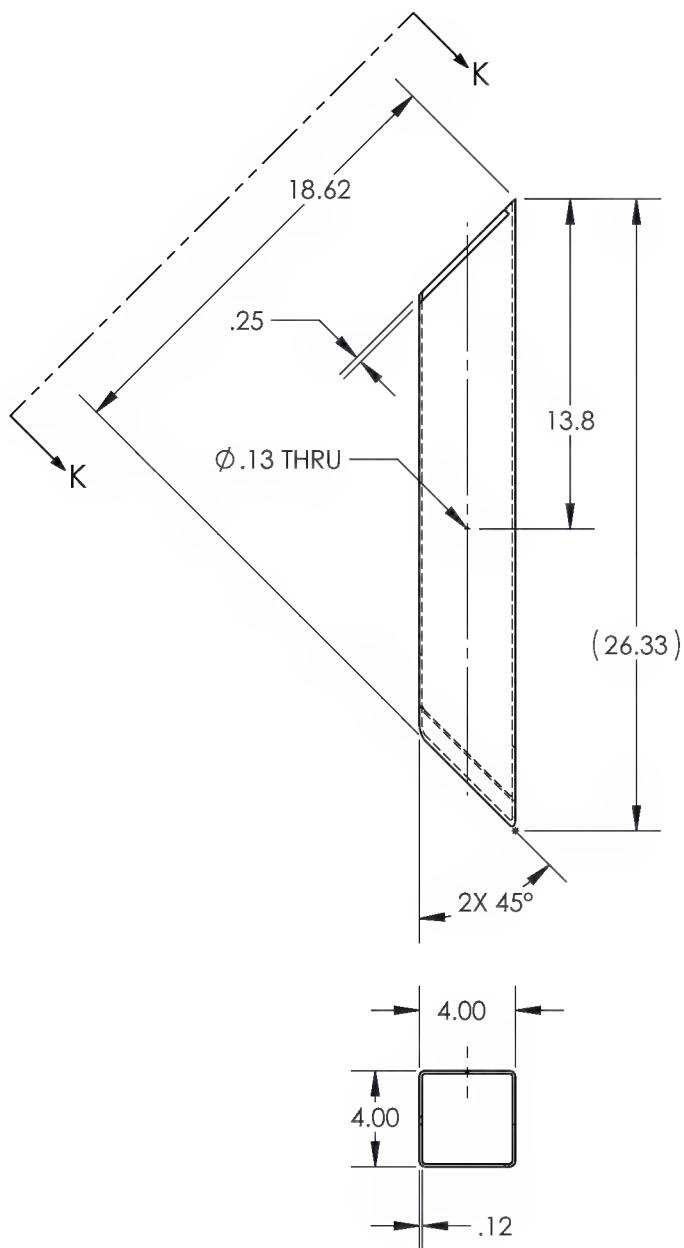
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
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DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-45 REV 1	
MATERIAL STEEL TUBE	
HEAT	
TREAT	
FINISH SEE -1 WELDMENT	
SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL	
SCALE	1:8
DATE	3/13/2014
SHEET 15 OF 29	

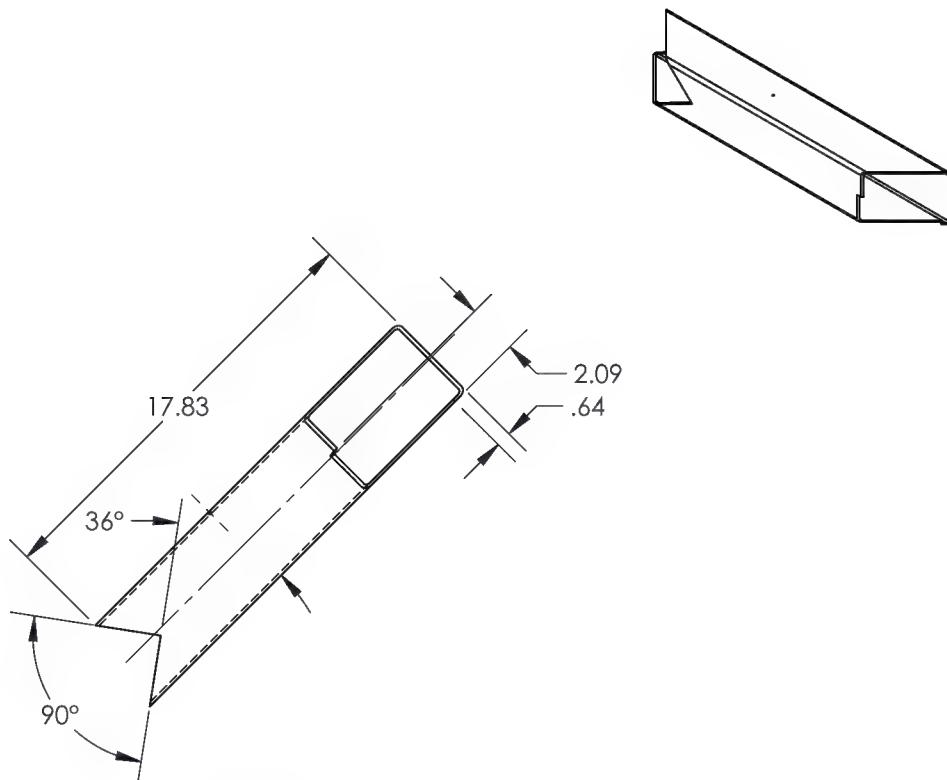
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				DESCRIPTION		DATE
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(-47)

MAIN FRAME INSIDE BRACE MIRROR

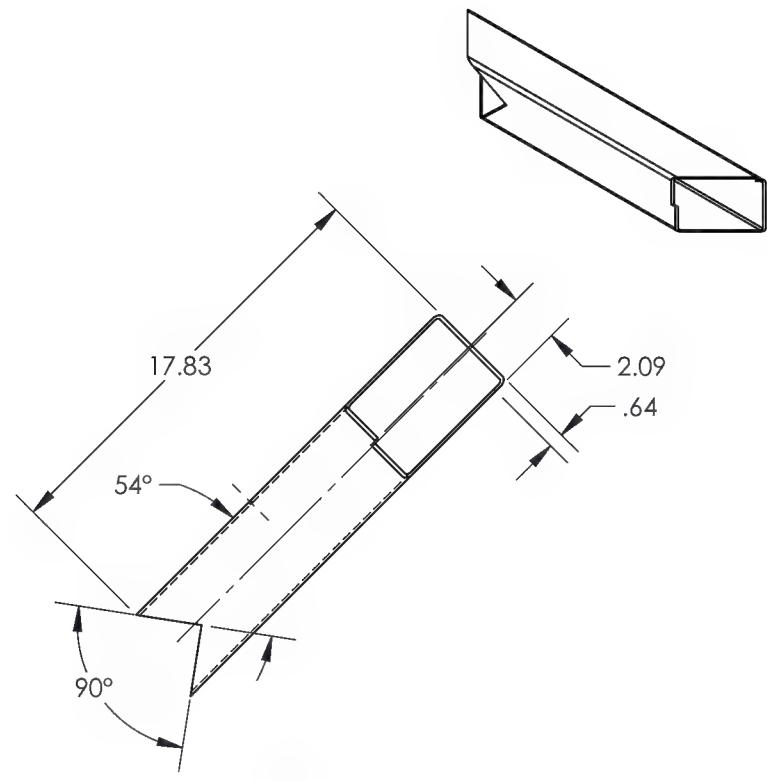
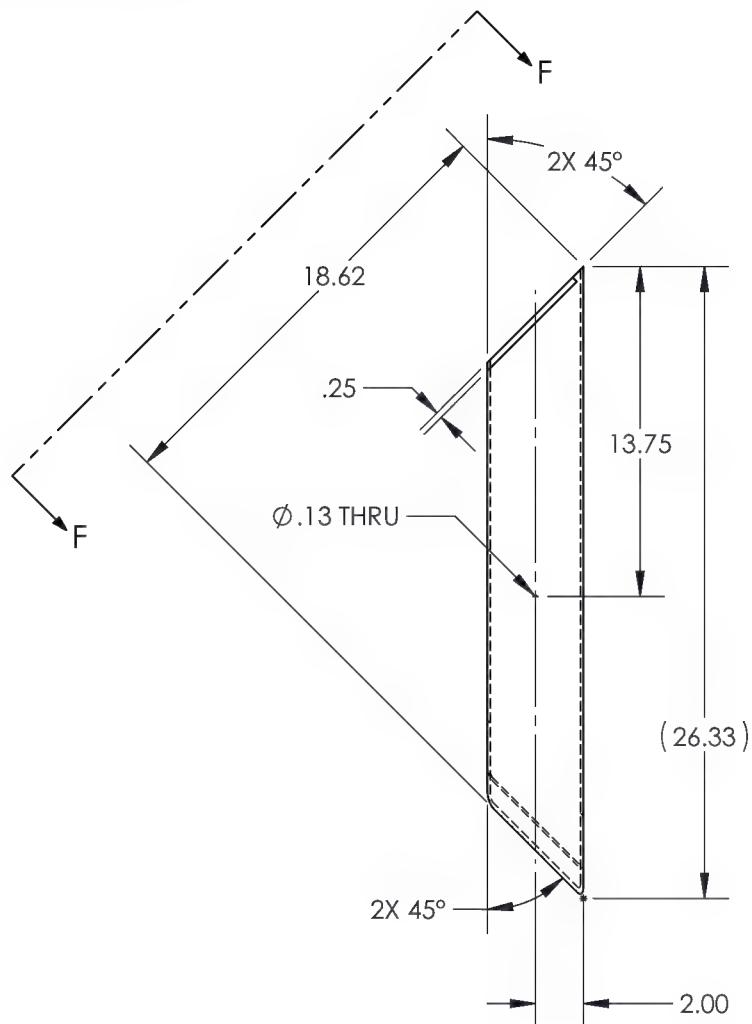


VIEW K-K

DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-47	
REV 1	
MAT'L A36/1018/1020 HR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
.X ± .1 SURFACES = 125 ✓	
SPEC	
DRAWN BY: GILBERT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE	1:8
DATE	3/13/2014
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VIEW F-F

MAIN FRAME INSIDE BRACE

-49

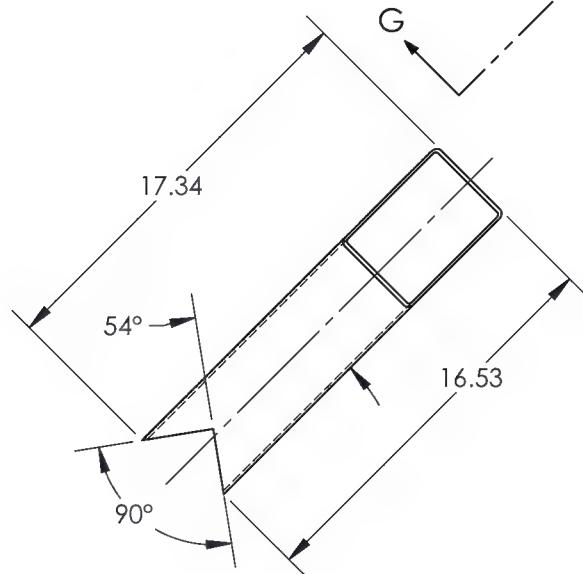
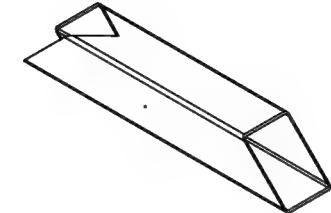
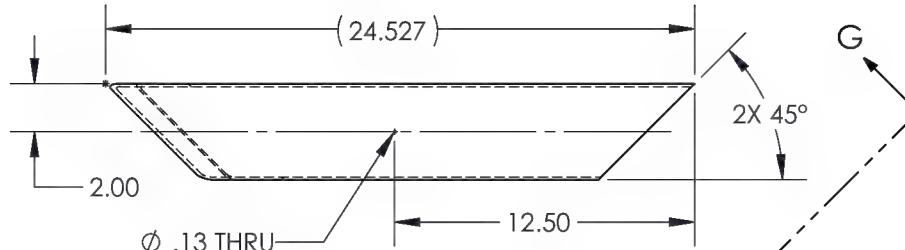
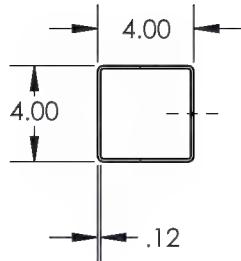
DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-49	
REV	1
MATERIAL STEEL TUBE	
HEAT	
TREAT	
FINISH SEE -1 WELDMENT	
SPEC	
DRAWN BY: GILBERT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE	1:8
DATE	3/13/2014
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UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ± 1°
X ± .1 SURFACES = 125 ✓

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

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VIEW G-G

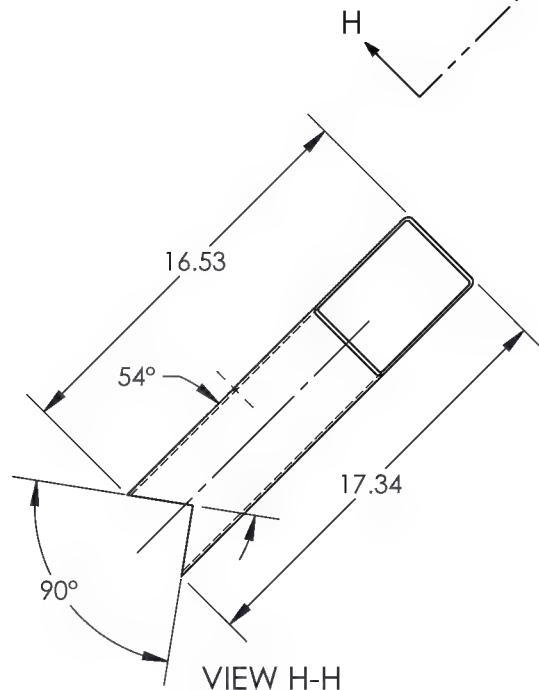
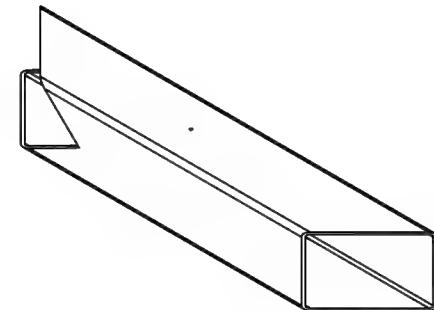
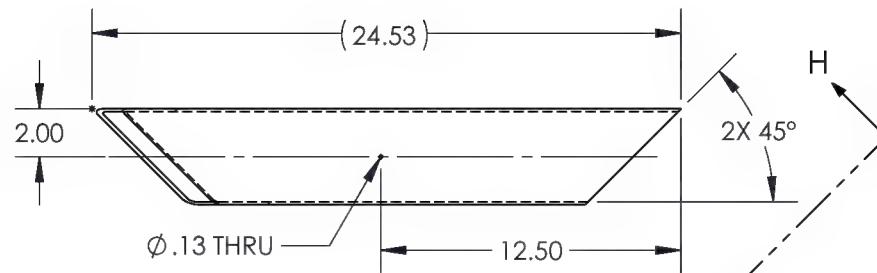
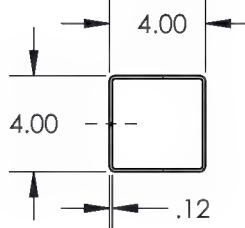
(-51)

MAIN FRAME TB INSIDE BRACE

DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-51	
REV	1
MATERIAL STEEL TUBE	
HEAT	
TREAT	
FINISH SEE -1 WELDMENT	
SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
.X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE	1:8
DATE	3/13/2014
SHEET 18 OF 29	

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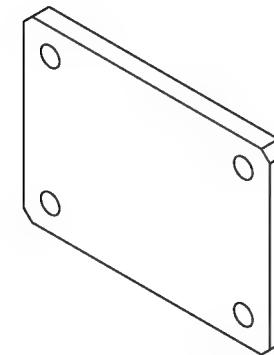
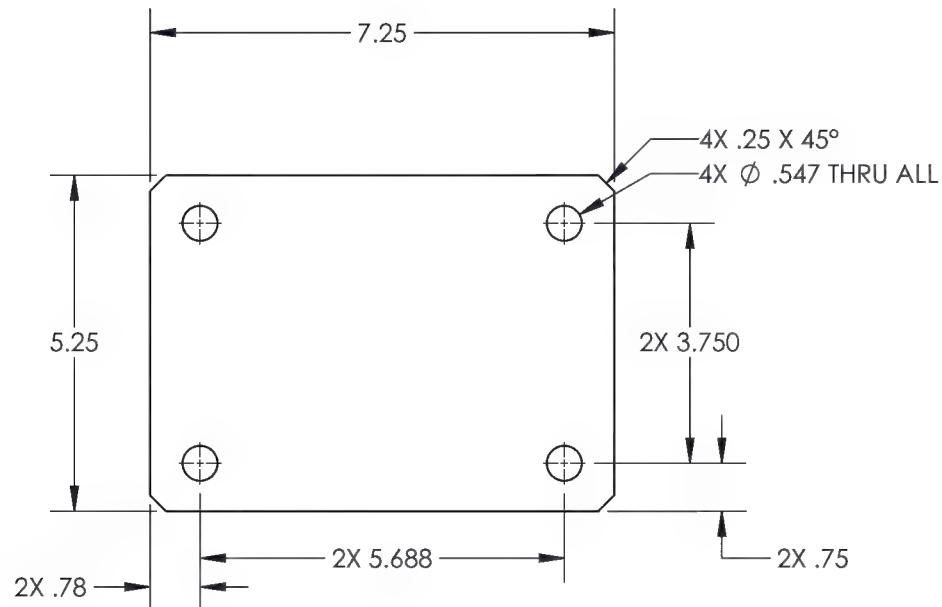
-53

MAIN FRAME TB INSIDE BRACE MIRROR

DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-53	
REV	1
MATERIAL STEEL TUBE	
HEAT	
TREAT	
FINISH SEE -1 WELDMENT	
SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
.X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL	
SCALE	1:8
DATE	3/13/2014
SHEET 19 OF 29	

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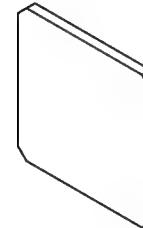
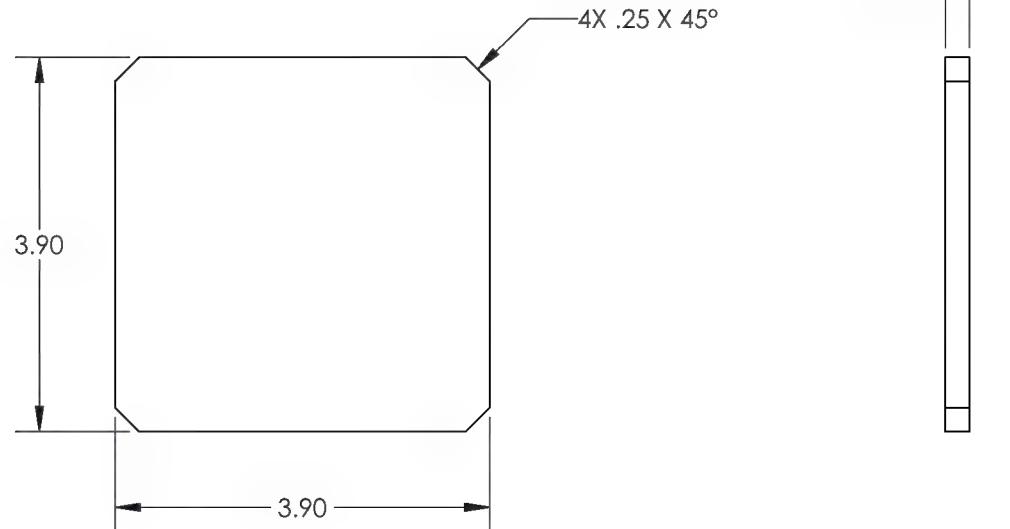
DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	RB T102012-55
REV	1
MATERIAL A36/1018/1020 HR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH SEE -1 WELDMENT	X ± .1 SURFACES = 125 ✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE	1:3
DATE	3/13/2014
SHEET 20 OF 29	

(-55)

MAIN FRAME WHEEL PLATE

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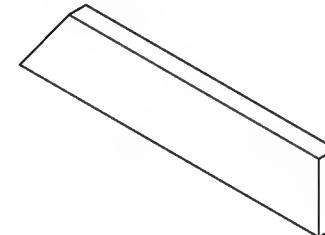
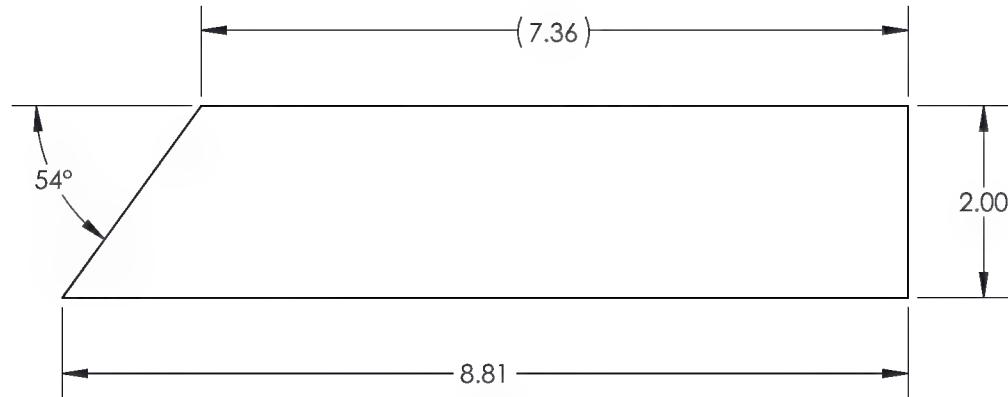
MAIN FRAME END CAP

-57

TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-57	
REV	1
MATERIAL A36/1018/1020 HR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH SEE -1 WELDMENT	X ± .1 SURFACES = 125 ✓
SPEC	
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE	1:2
DATE	3/13/2014
SHEET 21 OF 29	

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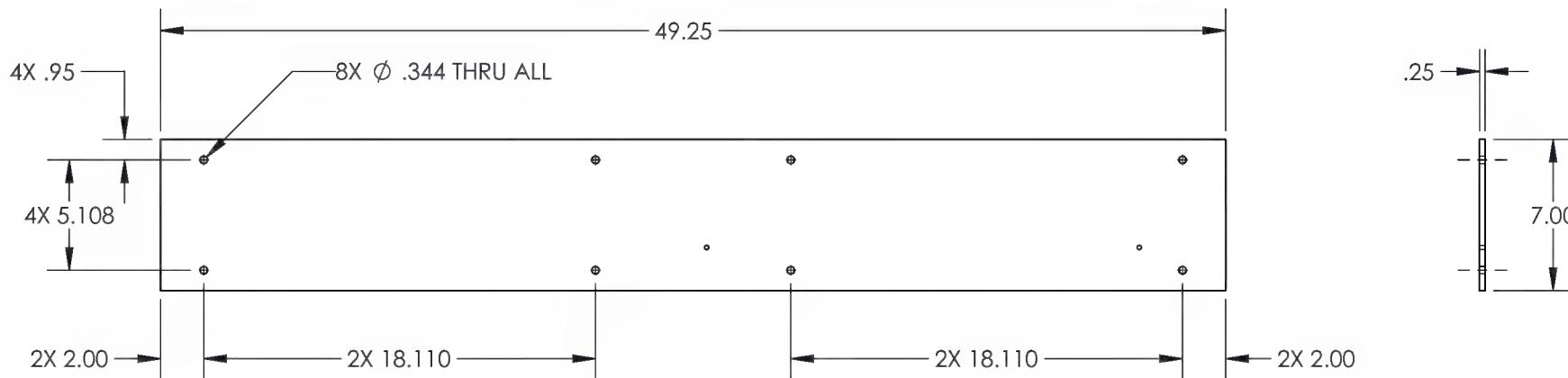
MAIN FRAME 2 UPRIGHT BRACE

(-59)

DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-59	
REV 1	
MATERIAL A36/1018/1020 HR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT .XXX ± .010 FRACTIONS ± 1/8	
TREAT .XX ± .03 ANGLES ± 1°	
FINISH SEE -1 WELDMENT .X ± .1 SURFACES = 125 ✓	
SPEC	
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE	1:2
DATE	3/13/2014
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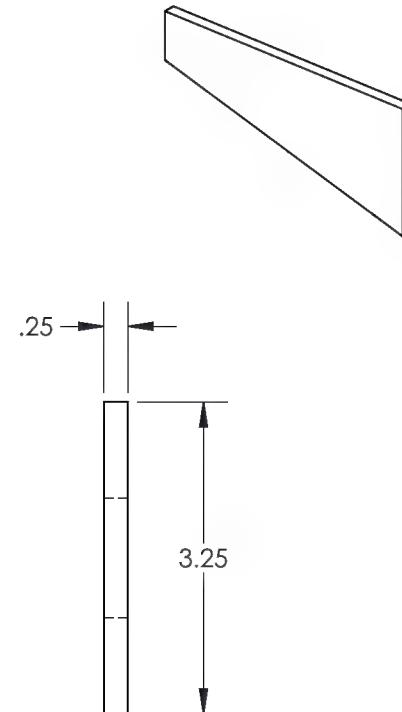
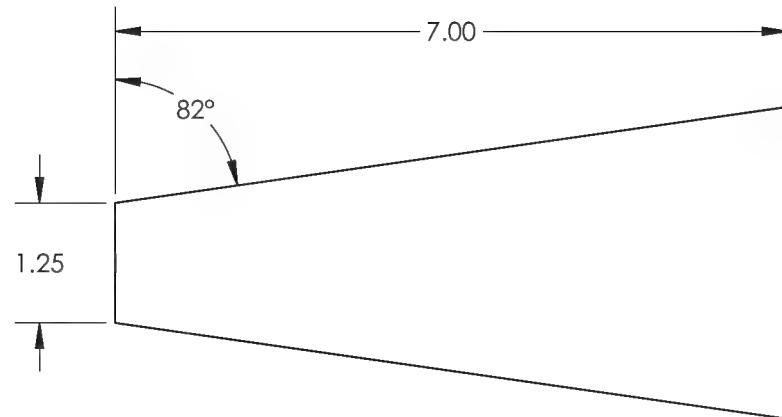
DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-61	
REV 1	
MAT'L A36/1018/1020 HR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH SEE -1 WELDMENT	X ± .1 SURFACES = 125 ✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE	1:8
DATE	3/13/2014
SHEET 23 OF 29	

-61

MAIN FRAME POWER PACK BASE

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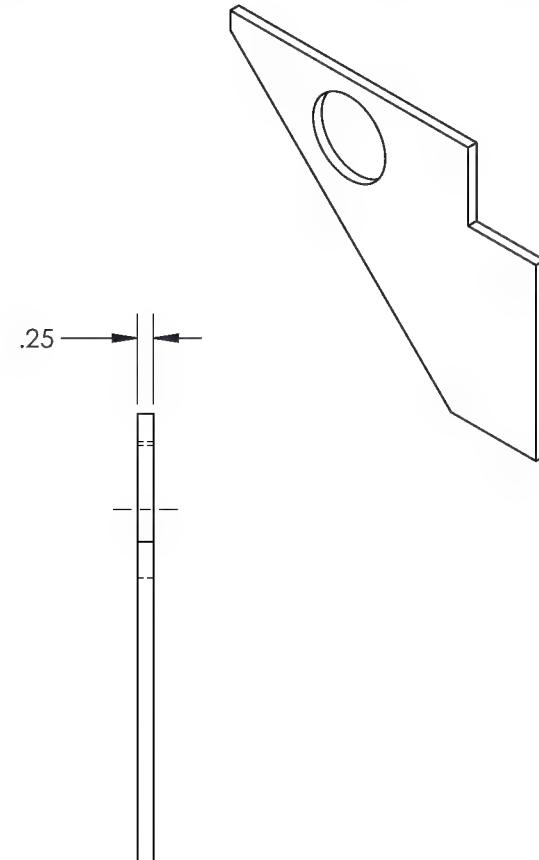
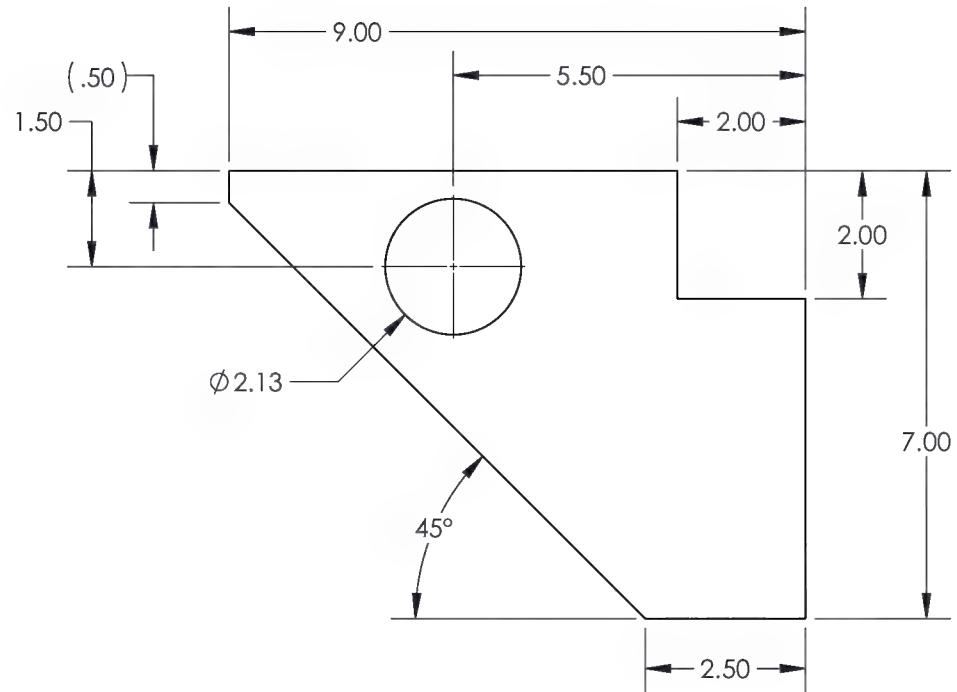
DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-63	
REV	1
MAT'L A36/1018/1020 HR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH SEE -1 WELDMENT	X ± .1 SURFACES = 125 ✓
SPEC	
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE	1:2
DATE	3/13/2014
SHEET 24 OF 29	

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MAIN FRAME POWER PACK GUSSET

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		DESCRIPTION	DATE	INITIAL
				APPROVED



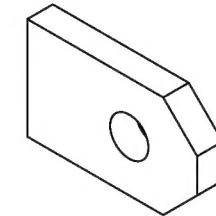
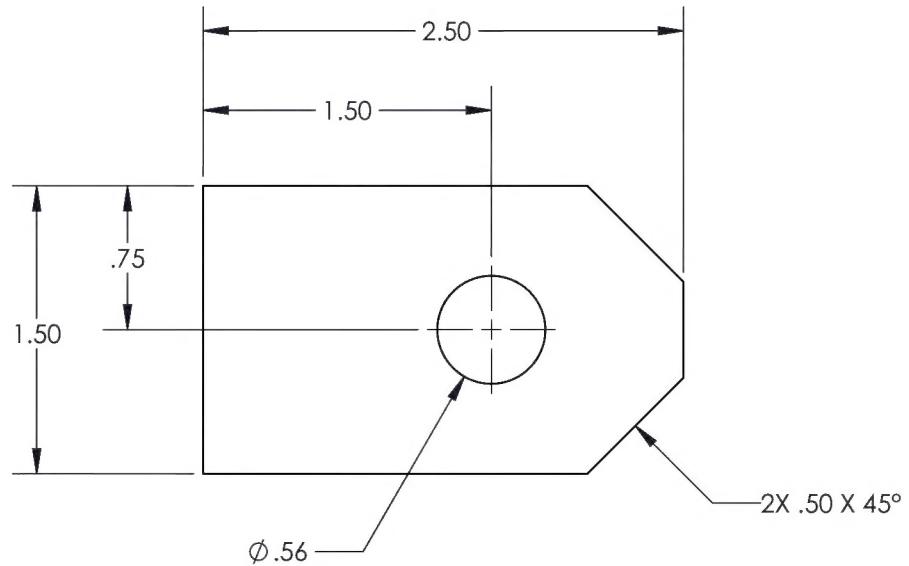
DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-65	
REV	1
MATERIAL A36/1018/1020 HR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH SEE -1 WELDMENT	
SPEC	X ± .1 SURFACES = 125 ✓
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE	1:3
DATE	3/13/2014
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(-65)

MAIN FRAME POWER PACK GUSSET 2

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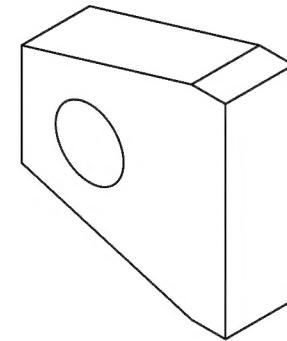
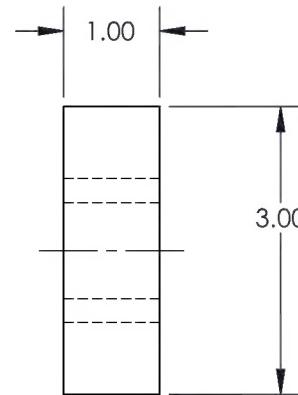
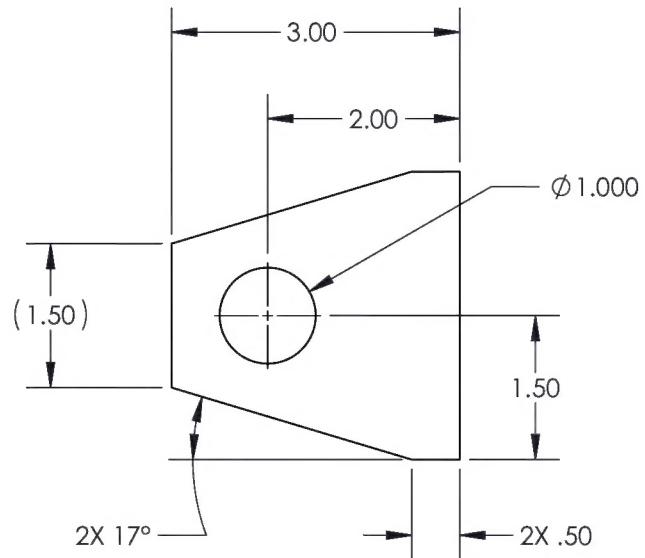
DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-67	
REV	1
MAT'L A36/1018/1020 HR	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH SEE -1 WELDMENT	X ± .1 SURFACES = 125 ✓
SPEC	
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE	1:1
DATE	3/13/2014
SHEET 26 OF 29	

(-67)

MAIN FRAME TOWBAR MOUNT

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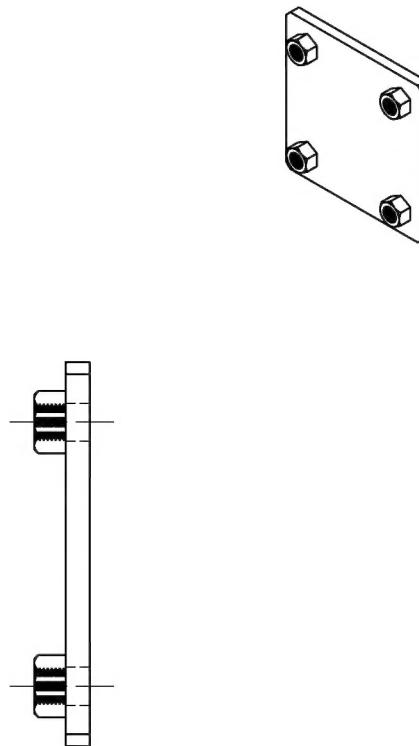
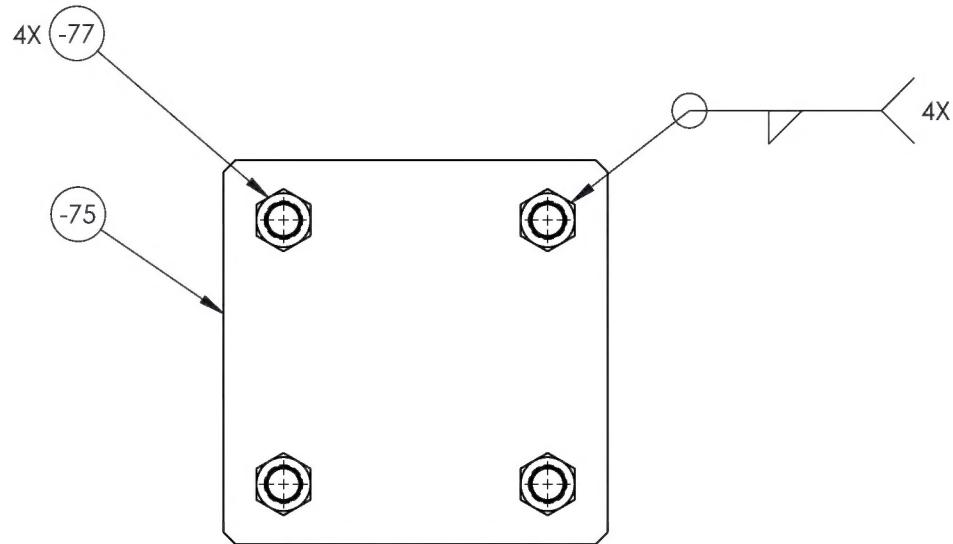
REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-69	
REV	1
MATERIAL A36/1018/1020 HR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT .XXX ± .010 FRACTIONS ± 1/8	
TREAT .XX ± .03 ANGLES ± 1°	
FINISH SEE -1 WELDMENT .X ± .1 SURFACES = 125 ✓	
SPEC	
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL BELL 212, 214B, 214ST, 412	
SCALE	1:2
DATE	3/13/2014
SHEET 27 OF 29	

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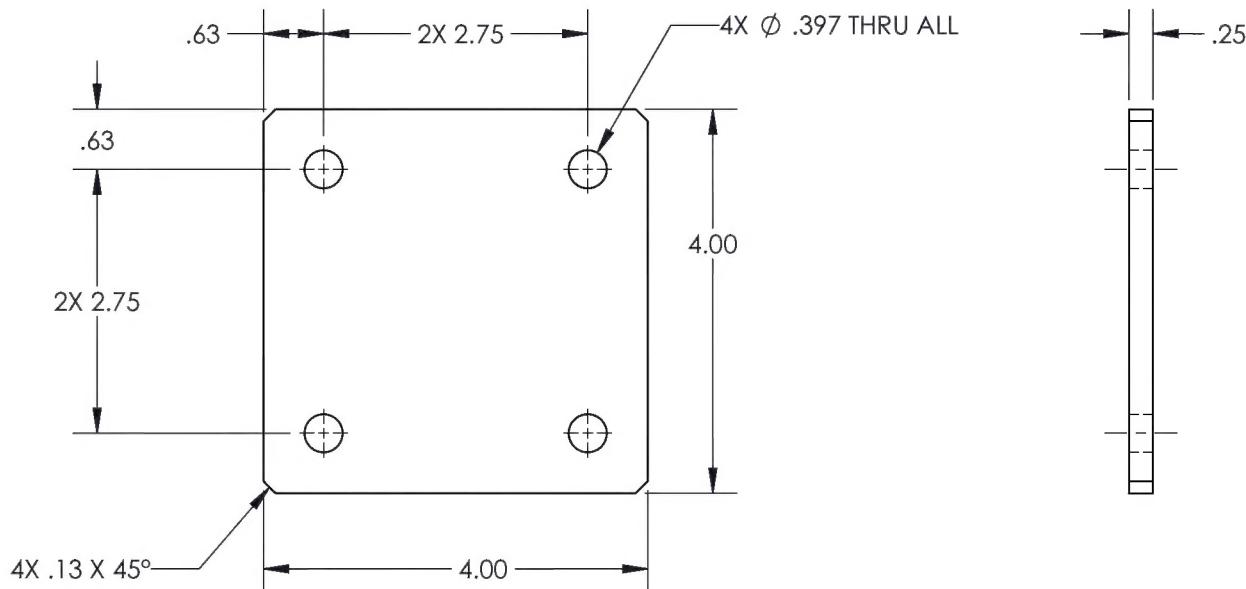
(-73)

WELDED PIVOT PLATE ASSEMBLY

TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-73 REV 1	
MATERIAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT	
.XXX ± .010 FRACTIONS ± 1/8	
FINISH SEE -1 WELDMENT	
.XX ± .03 ANGLES ± 1°	
SPEC	
.X ± .1 SURFACES = 125 ✓	
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE	1:2
DATE	3/13/2014
SHEET 28 OF 29	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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MAIN FRAME WELD PIVOT PLATE

(-75)

TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-75 REV 1	
MATERIAL A36/1018/1020 HR UNLESS OTHERWISE SPECIFIED	
HEAT DIMENSIONS ARE IN INCHES	
TREAT FRACTIONS $\pm \frac{1}{8}$	
FINISH SEE -1 WELDMENT ANGLES $\pm 1^\circ$	
SPEC SURFACES = 125	
DRAWN BY: GILBERT 1. BREAK ALL SHARP EDGES CHECKED: CLOUGH .015 x 45° OR .015R	
OPPS APPR: ANDERSON 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
QA APPR: LINDSAY 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
APPROVED: GILBERT USED ON MODEL	
SCALE 1:2	DATE 3/13/2014
SHEET 29 OF 29	